Quality Control

Work Order Wednesday, Octobe												Page 1
Revision ID:	3454-1 ushing			Accept					Setup	Start Stop		
Start Date: 10 Required Date: 10 Reference:	0/5/2011 0/14/2011	Start Qty: 20.00 Req'd Qty: 20.00			Cust Iter Custome							
	Process Plan	n:	Date: //-/// Date:	Y-5 Tooling: SPC (Y/N):		Date:			Run	Start Stop		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr					,					
D3454	Rev I	В										
100 Hardinge Hardinge CNC Lathe Si		Hardinge CNC LATHE Memo		0.00 0.00				20		0	of	If illula
				& DWG D3454 ,□FOLIO □ □2-DEBURR AS REQ	UIRED							
110 QC .		QC2- Inspect parts off n Memo	achine FAI/FAIB	0.00				20)	any,	11 11/10/
Quality Control		QC8- Inspect parts - sec	ond check	0.00	54 M.	10.2	4	20		b		

Dart Aerospace Ltd

W/O:	<u> </u>			W	ORK ORDER CHAN	GES			•	
DATE	STE	Р	PRO	CEDURE CHA	NGE	Ву	D	ate Qty	Approval Chief Eng /	Approval QC Inspector
									Prod Mgr	
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									-	
		1	DAD "	F4-0-4-		NCD: V	os No	DOA:	Date:	
Part	ио:		PAR #:							
		Resolu	ution:					ea:	Date	
NCR:				WORK ORL	ER NON-CONFORM	VIANCE (IN	CR)			
DAT	E STI	ED	Description of NC	12421	Corrective Action Se Action Description	ection B	gn &	Verification	Approval	Approval
DAI	_ 3		Section A	Initial Chief Eng	Chief Eng		ate	Section C	Chief Eng	QC Inspector
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									}	

Work Order ID 74730

Wednesday, October 05, 2011 2:34:17 PM



Page 2

Item ID:

D3454-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name: Bushing

10/5/2011

Start Qty: 20.00

Required Date: 10/14/2011

Req'd Qty: 20.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____

Date:

Tooling:

Date:

Run

Start



Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/ **Work Center ID**

130

Packaging

Operation Description

Identify as per dwg & Stock Location:

0.00

Tool # Plan Code

Accept Qty

Reject Otv

Reject Number

Insp. Stamp

Packaging

Memo

Memo

0.00

80 11-10-25

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart Aei	ospace	Lta							
W/O:			WO	RK ORDER CHANGE	S			·. •	
DATE	STEP	PRO	CEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								5	
Part No		PAR #:		gory:					
	Re	esolution:	Disposition	n:	QA: N/C C	losed:		Date: _	
NCR:	r		WORK ORD	ER NON-CONFORMA	NCE (NCI	₹)			
		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sec	tion C	Chief Eng	QC Inspector
								<u>.</u>	

Picklist Print

Wednesday, October 05, 2011 2:34:23 PM

Work Order ID: 74730

Parent Item:

D3454-1

Parent Item Name: Bushing



Start Date: 10/5/2011

Required Date: 10/14/2011

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV. A 05.11.17

NEW ISSUE

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No				f	23.1390		1 0,94	510M	ff	11/16/24

303 Round Bar 1.00

Location	Loc Qty	Loc Code	
MAT028	23.139		
116700	1.107		<u> </u>
117550	1.2		
117598	13.74		
118008	7.092		0.975

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W/O:		WORK ORDER C	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
_							
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date: _	

Resolution: _____ Disposition: _____ QA: N/C Closed: ____ Date: ____

NCR:		,	WORK ORD	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
							-	
			1					

DART AEROSPACE LTD	Work Order:	14730
Description: Bushing	Part Number:	D3454-1
Inspection Dwg: D3454 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	\$0.3165	1			
Ø0.435	+0.000/-0.005	\$ 0.4314	V			
0.420	+0.005/-0.000	0.421	V			
0.060	+0.010/-0.000	0-0615	V /	-		
Ø1.00	±0.0 3 0/-0.0 90	60.9945	/			
	Re					
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	-					
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		1				-

Measured by: It Isul	Audited by:	Prototype Approval:	N/A
Date: 11/10/24	Date: 1. 10 - 24	Date:	N/A

Rev	Date	Change	Revised by	Approved_
Α	06.09.01	New Issue	KJ/JLM ,	1
В	09.05.04	Dimension 0.060 was 0.60	KJ/DD A	
			'() '	/ /

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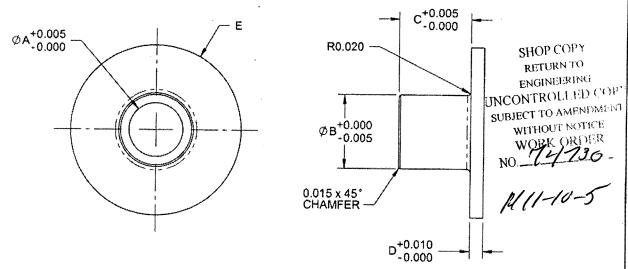
W/O:			W	ORK ORDER CHAN	IGES				About 1981			
DATE STEP			CEDURE CHA	NGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No:		PAR #:	Fault Cate	gory:	NCR:	Yes 1	do DQ/	A :	Date:			
Resolution:			Dispositio	isposition: QA: N/C Closed: _					l: Date:			
NCR:		. W	ORK ORD	ER NON-CONFORM	JANCE (I	NCR)						
DATE	STEP	Description of NC	Initial Action Description			Verific		ation	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng		ign & Date	Section	on C	Chief Eng	QC Inspector		
	- - -											
NOTE: Da	ate & initia	all all entries				·········						

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



DESIGN D		DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECK	(ED	APPROVED #	DRAWING NO. D3454	REV. B SHEET 1 OF 1			
 DATE	05.1	2.05	TITLE BUSHING	SCALE 2:1			
Α	0:	5.09.02	NEW ISSUE				
В	0:	5.12.05	REVISE -5/-7				

RELEASED 05.12.09



D3454-X

1) SPECIFICATION: D3454-X BUSHING



WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
 2) FINISH: NONE
 3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES
 6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Dart Ae	rospace	e Ltd								
W/O:			V	ORK ORDER CHANG	iES		··········			
DATE STEP		PR	OCEDURE CH			By Date Qty			Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·	
Part No	:	PAR #:	Fault Ca	tegory:	NCR	: Yes N	lo DQ	A:	Date:	
			Disposition: QA: N/C Clos			sed: Date:				
NCR:				DER NON-CONFORMA						
DATE	CTED	Description of NC	Corrective Action Section		ion B	on B		antion	,	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC inspector	
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